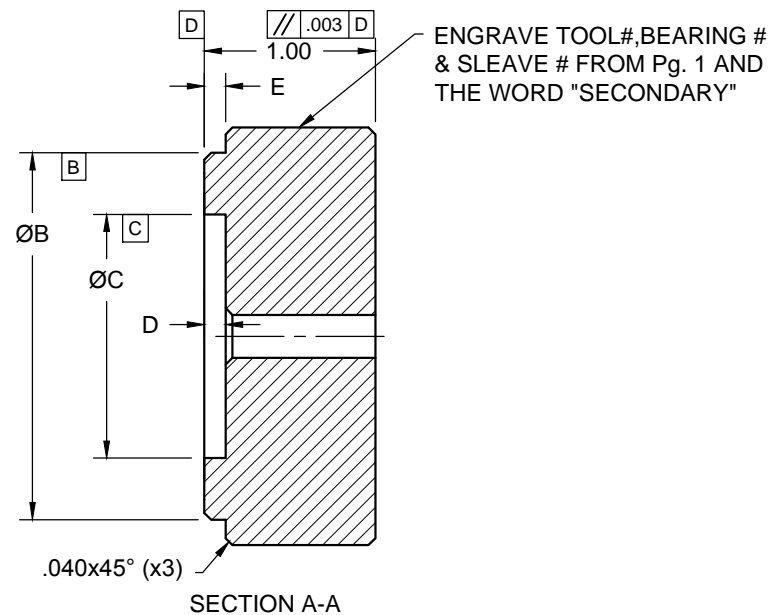

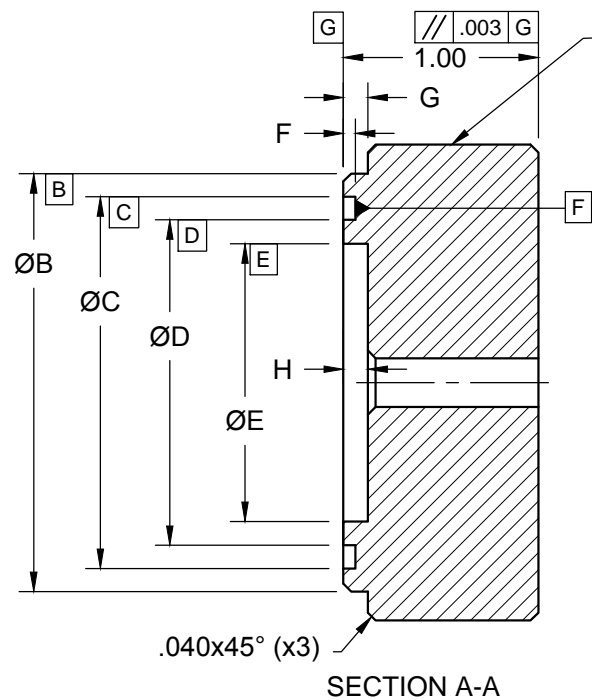
 RED BARN MACHINE	
TITLE KSTCH##-SL SERIES DP TRI-ROLLER SLEEVE SWAGING TOOLS FOR BACB10CH## BEARINGS	
DWG NO.	REV 1
TOOL# (see chart)-15	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°	DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC BLACK OXIDE USED ON BEARING
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	SEE Pg. 1
SCALE NTS	DATE 11-9-08 SHEET 9 of 9



 RED BARN MACHINE	
TITLE KSTCH##-SL SERIES DP TRI-ROLLER SLEAVE SWAGING TOOLS FOR BACB10CH## BEARINGS	
DWG NO.	REV 1
TOOL# (see chart)-13	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°	DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC BLACK OXIDE USED ON BEARING SEE Pg. 1
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 11-9-08 SHEET 8 of 9




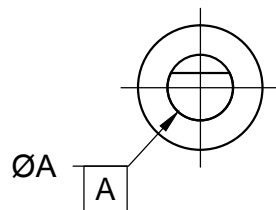
ENGRAVE TOOL#, BEARING #
& SLEEVE # FROM Pg. 1 AND
THE WORD "PRIMARY"

NOTES

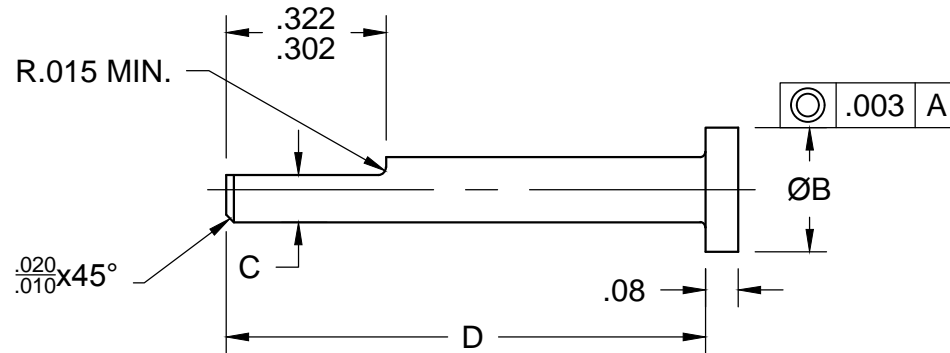
1. BREAK ALL SHARP CORNERS (.015/.03).

[illegible]

 RED BARN MACHINE			
TITLE KSTCH##-SL SERIES DP TRI-ROLLER SLEAVE SWAGING TOOLS FOR BACB10CH## BEARINGS			
DWG NO. TOOL# (see chart)-11			REV 1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± 5° .X ± .1		DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH BLACK OXIDE SPEC USED ON BEARING SEE Pg. 1	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING			
SCALE NTS	DATE 11-9-08	SHEET 7 of 9	



-9
PIN



TOOL #	ØA	ØB	C	D	MATERIAL
KST-BACB10CH	+0.000 -0.001	+0.005 -0.002	+0.000 -0.020	+0.020 -0.020	
KSTCH40-SL	.129	.188	.104	.925	MCMaster-CARR PN: 98378A909
KSTCH50-SL	.129	.188	.104	.925	MCMaster-CARR PN: 98378A909


NOTES
1. BREAK ALL SHARP CORNERS (.015/.03).

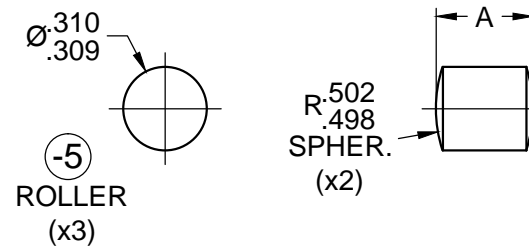
RED BARN MACHINE			
TITLE KSTCH##-SL SERIES DP TRI-ROLLER SLEEVE SWAGING TOOLS FOR BACB10CH## BEARINGS			
DWG NO. TOOL# (see chart)-9			REV 1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 X ± .1		DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH BLACK OXIDE SPEC USED ON BEARING SEE Pg. 1	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING			
SCALE	NTS	DATE	11-7-08
		SHEET	6 of 9




NOTES

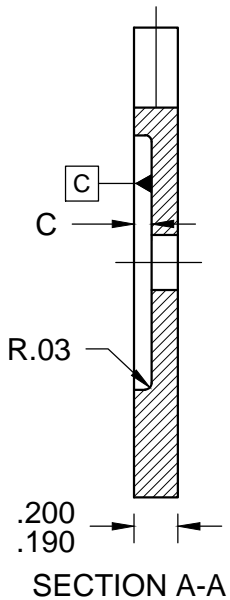
1. BREAK ALL SHARP CORNERS (.015/.03).

 RED BARN MACHINE			
TITLE KSTCH##-SL SERIES DP TRI-ROLLER SLEAVE SWAGING TOOLS FOR BACB10CH## BEARINGS			
DWG NO. TOOL# (see chart)-7			REV 1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°		DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC USED ON BEARING SEE Pg. 1	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES 015 ± 45° PR 015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING			
SCALE NTS	DATE 11-7-08	SHEET 5 of 9	




TOOL #	A	MATERIAL			
KST-BACB10CH	+.001 -.001				
KSTCH40-SL	.250	.310 MINUS	GAUGE PIN	MSC#89031009	
KSTCH50-SL	.360	.310 MINUS	GAUGE PIN	MSC#89031009	

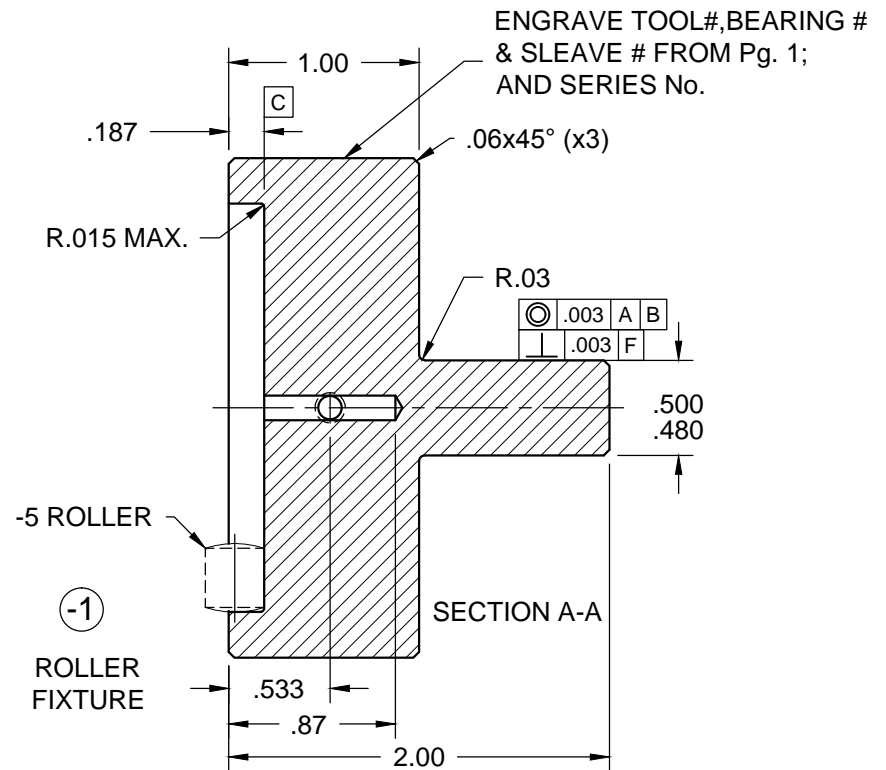
 RED BARN MACHINE			
TITLE KSTCH##-SL SERIES DP TRI-ROLLER SLEEVE SWAGING TOOLS FOR BACB10CH## BEARINGS			
DWG NO.		TOOL# (see chart)-5	REV 1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		DRAWN BY: PERRITT	
TOLERANCES ON:		APPROVED	
DECIMALS		HEAT TREAT	
.XXX ± .005		FINISH	
.XX ± .01		SPEC	
X ± .1		USED ON BEARING	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		SEE Pg. 1	
SCALE NTS	DATE 11-7-08	SHEET 4 of 9	




NOTES

1. BREAK ALL SHARP CORNERS (.015/.03).

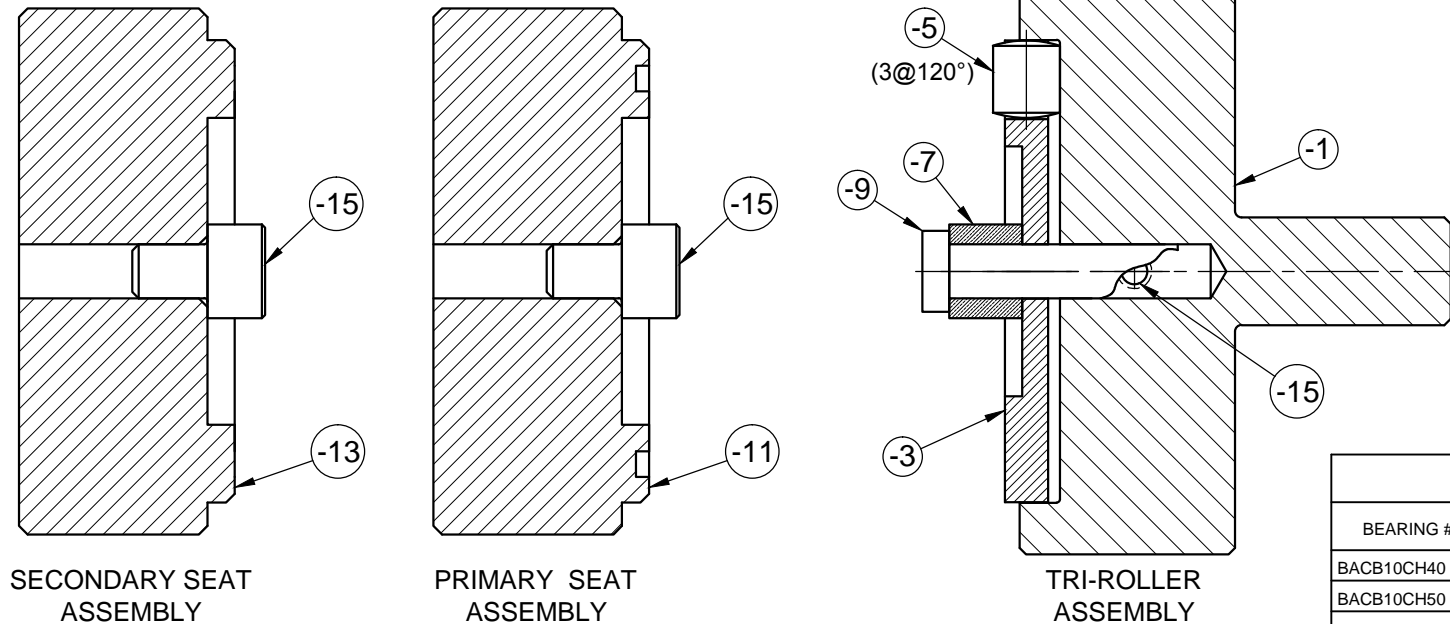
 RED BARN MACHINE	
TITLE KSTCH##-SL SERIES DP TRI-ROLLER SLEAVE SWAGING TOOLS FOR BACBIOCH## BEARINGS	
DWG NO.	REV 1
TOOL# (see chart)-3	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± .5°	DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON BEARING SEE Pg. 1
SCALE NTS	DATE 11-07-08
SHEET 3 of 9	



 RED BARN MACHINE	
TITLE KSTCH##-SL SERIES DP TRI-ROLLER SLEAVE SWAGING TOOLS FOR BACBIOCH## BEARINGS	
DWG NO.	REV 1
TOOL# (see chart)-1	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°	DRAWN BY: PERRITT APPROVED HEAT TREAT RC 55-60 FINISH SPEC. BLACK OXIDE USED ON BEARING SEE Pg. 1 _____ _____
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR. 015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 11-9-08
SHEET 2 of 9	

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REV		REVISIONS	DATE	INITIAL	APPROVED
1		ADDED STCH40-SL TO TOOL LIST.	2/23/09	WP	



DRILL PRESS TRI-ROLLER SLEEVE SWAGING TOOL ASSEMBLY FOR BEARINGS

NOTES

1. -5 ROLLERS MUST TURN FREELY IN -3 RETAINER POCKETS.
2. -5 ROLLERS & -3 RETAINER MUST TURN FREELY WHEN TOOL IS COMPLETELY ASSEMBLED.
3. TOOL No. ENDING WITH THE LETTERS -SL ARE USED FOR SLEEVE SWAGING ONLY.

BEARINGS & TOOLS COVERED		
BEARING #	SLEEVE #	TOOL #
BACB10CH40	185A4101-57	KSTCH40-SL
BACB10CH50	185A4101-55	KSTCH50-SL

ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	B/O INFORMATION OR SPECIFICATIONS	Pg.
		-1	1	ROLLER FIXTURE	SEE CHART	2
		-3	1	RETAINER	SEE CHART	3
		-5	3	ROLLER	SEE CHART	4
		-7	1	GUIDE	SEE CHART	5
		-9	1	PIN	SEE CHART	6
		-11	1	PRIMARY SEAT	SEE CHART	7
		-13	1	SECONDARY SEAT	SEE CHART	8
		-15	SEE CHART	LOCATING PIN	SEE CHART	9
	B/O	-17	1	SOCKET HEAD SET SCREW	#8-32 x 1/4	N/S

TITLE		KSTCH##-SL SERIES DP TRI-ROLLER SLEEVE SWAGING TOOLS FOR BACB10CH## BEARINGS	
DWG NO.	SEE CHART ABOVE FOR TOOL No.	REV	1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		DRAWN BY: PERRITT	
TOLERANCES ON:		APPROVED	
DECIMALS		HEAT TREAT LISTED PER ITEM	
.XXX ± .005		FINISH LISTED PER ITEM	
.XX ± .01		USED ON BEARING	
.X ± .1		SEE ABOVE	
UNLESS OTHERWISE SPECIFIED		1. BREAK ALL SHARP EDGES	
.015 x 45° PR .015 R		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE	NTS	DATE	11-7-08
		SHEET	1 of 9

							RED BARN MACHINE	
TITLE							---	
DWG NO.							---	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1							DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC USED ON MODEL	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING								
SCALE NTS							DATE 8-15-07	
							SHEET 1 of 1	

NOT APPROVED FOR PRODUCTION

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED

PART #	QTY	DESCRIPTION
-1	1	--

DRAWN BY: PERRITT	<div>RB</div> RED BARN MACHINE		
CHECKED	TITLE		
HEAT TREAT FINISH SPEC	TITLE		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	FRACTIONS ± 1/32 ANGLES ± .5°		REV.
USED ON MODEL ?	DWG NO. PART #		
	SCALE NTS	DATE 1-28-06	SHEET 1 of 1
	UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		